

Date: Friday, 13/02/2009 1:02:41 PM
 User: Julie Dawson

Process Sheet

Customer	: CU-DAR001 Dart Helicopters Services		Drawing Name	: HINGE BRACKET	
Job Number	: 45798		Part Number	: D28581	
Estimate Number	: 10348		Drawing Number	: D2858 REV B	
P.O. Number	:		Project Number	: N/A	
This Issue	: 13/02/2009 S.O. No. :		Drawing Revision	: B	
Prsht Rev.	: NC		Material	:	
First Issue	: / /		Due Date	: 20/02/2009	
Previous Run	: 43364		Qty:	248 Um: Each	
Written By	:				
Checked & Approved By	: <u>JUL 09 02.13</u>				
Comment	: Est C 00.06.22 Removed P/O for powder coat EC				

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :	
1.0	M6061T6B1500X01250	6061-T6 Bar 1.50 x 1.25	<i>scrpt 7/11</i>
		Comment: Qty.: 0.1767 f(s)/Unit Total : 42.9417 f(s) Material: 1.50" X 1.25" 6061-T6 (QQ-A-225/8 or QQ-A-250/11 or QQ-A-200/8) (M6061T6B15001250) Batch <u>M107461</u>	
2.0	BAND SAW	BAND SAW	<i>88 09/02/18</i>

Comment: BAND SAW
 Cut blanks 6.02"
 Note: 1 Blank Makes 3 Parts

3.0 HAAS1 HAAS CNC VERTICAL MACHINING #1 *88 09/02/18*

Comment: HAAS CNC VERTICAL MACHINING #1
 1-Machine per folio D2858-

2-Deburr as per Dwg D2858000

~~2~~ ~~3~~

mmf 09/02/19

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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Drawing Name: HINGE BRACKET

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Job Number:



Seq. #: Machine Or Operation:

Description :

4.0 QC2

INSPECT PARTS AS THEY COME OFF MACHINE



(30)

Comment: INSPECT PARTS AS THEY COME OFF MACHINE

mw 09/02/09

5.0 QC8

SECOND CHECK



(30)

Comment: SECOND CHECK

SD

09/02/20

(30)

6.0 HAND FINISHING1

HAND FINISHING RESOURCE #1



(30)

Comment: HAND FINISHING RESOURCE #1

Acid etch and Alodine as per QSI 005 4.3

7.0 POWDER COATING

POWDER COATING



Comment: POWDER COATING

Powder Coat Gloss White (Ref. 4.3.5.1) per Dart QSI 005 4.3

START TIME: 10:20 AM

OVEN TEMPERATURE: 3200F

FINISH TIME: 10:50 AM

09-02-23

(30)

8.0 QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



(30)

Comment: INSPECT POWDER COAT

BL 09-02-24

9.0 PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: _____

10/2/25 (30)

10.0 QC21

FINAL INSPECTION/W/O RELEASE



09/02/25 (30)

Comment: FINAL INSPECTION/W/O RELEASE

Job Completion



10/2/25

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

DART AEROSPACE LTD		Work Order:	W15798
Description: Hinge Bracket		Part Number:	D2858-1
Inspection Dwg: D2858 Rev: B		Page 1 of 1	

FIRST ARTICLE INSPECTION CHECKLIST

First Article Prototype

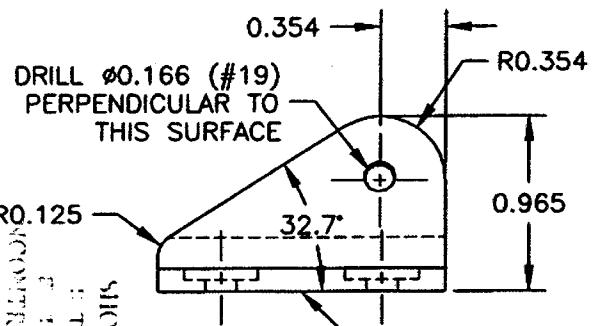
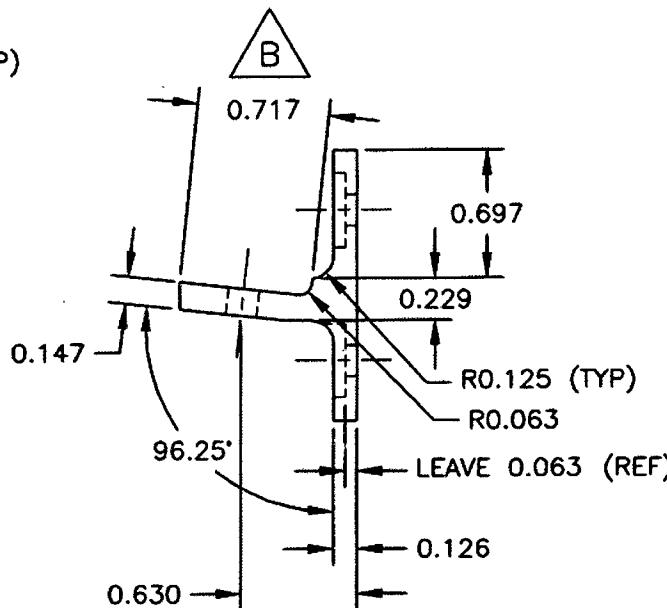
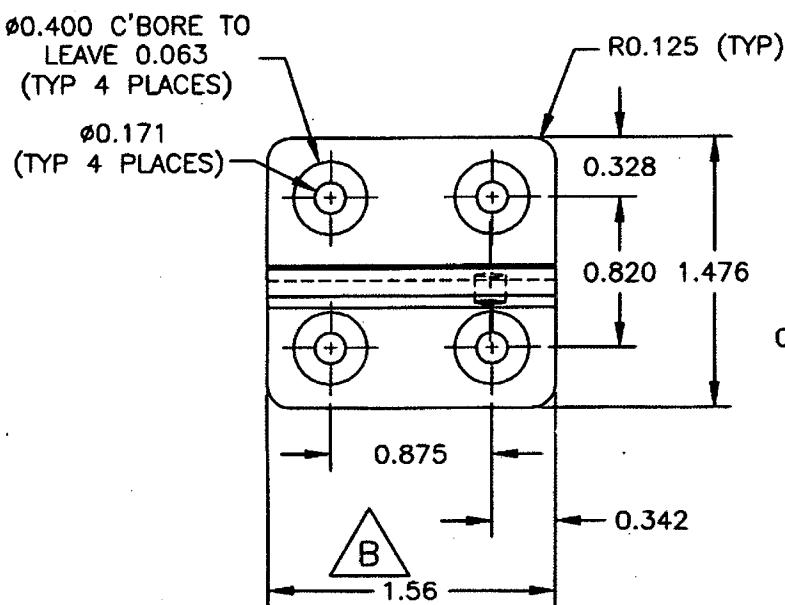
Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
Ø0.171	+0.005/-0.001	Ø.174	✓			
Ø0.400	+0.006/-0.001	Ø.400	✓			
R0.125	+/-0.010	R.125	✓			
0.328	+/-0.010	.327	✓			
0.820	+/-0.005	.820	✓			
1.476	+/-0.010	1.475	✓			
0.342	+/-0.010	.340	✓			
0.875	+/-0.005	.875	✓			
1.56	+/-0.030	1.57	✓			
0.147	+/-0.010	.149	✓			
0.717	+/-0.010	.717	✓			
0.697	+/-0.010	.696	✓			
0.229	+/-0.010	.229	✓			
R0.125	+/-0.010	R.125	✓			
R0.063	+/-0.010	R.063	✓			
0.063	+/-0.010	.059	✓			
0.126	+/-0.010	.123	✓			
0.630	+/-0.010	.630	✓			
R0.354	+/-0.010	R.354				
0.965	+/-0.010	.969	✓			
Ø0.166	+0.005/-0.001	Ø.167	✓			
R0.125	+/-0.010	R.125	✓			
32.7°	+/-0.5°	32.7°	✓			

Measured by:	<i>mmj</i>	Audited by:	<i>SA</i>	Prototype Approval:	N/A
Date:	09/02/19	Date:	09/02/20	Date:	N/A

Rev	Date	Change	Revised by	Approved
A	07.10.30	New Issue	KJ/EC/DD	<i>MM</i>

DARTDA COPY
Date**RELEASED**
99.07.09 KE

DESIGN	DRAWN BY	DART AEROSPACE LTD		
CHECKED	APPROVED	DRAWING NO.	REV. B	SHEET 1 OF 1
	KE	D2858		
DATE		99.02.28		
A		98.12.14	NEW ISSUE	
B		99.02.28	0.717 WAS 0.667, 1.56 WAS 1.559	

ENGRAVE P/N CENTERED ON
BASE 0.003 DEEP (0.010 MAX)D2858-1 SHOWN
D2858-2 OPPOSITE

MATERIAL: 6061-T6 ALUMINUM (QQ-A-250/11) OR (QQ-A-200/8) OR (QQ-A-225/8)

FINISH: ACID ETCH AND ALODINE PER DART QSI 005 4.1

POWDER COAT WHITE (4.3.5.1) PER DART QSI 005 4.3

TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

45798
SICK COPY
: TURN TO
: HINGE BRACKET
: JETT TO MOUNTMENT
: MOUNTING
: MOUNTING
: MOUNTING